

Work Order ID 51511

August 25, 2009 1:34:24 PM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Replacement Skidtube

Start Date: 8/24/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/24/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

mt

Date:

08-25

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

NAH

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend I

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

> DP 9-9-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

i  - ALM 9-3-28

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Scrub

 *1*

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R[1111] Aluminum Rod H111111

PD 09.09.28

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R[1111] Aluminum Rod

H109213

PD 09.10.02

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

9-10-06 A42M

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Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00

⇒ 50/10/06

QC

Memo

0.00

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00

⇒ 50/10/06

QC

Memo

0.00

Quality Control

170

Pressure Wash per QSI005 4.3

0.00

⇒ 50/10/06

HandFinish

Memo

0.00

Hand Finishing

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QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 112260</i> Memo START TIME: <i>12:45</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>1:15</i>	0.00 0.00	<i>BR 09-10-7</i>			<i>①</i>			
190 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	<i>M 09/10/08</i>			<i>①</i>	<i>②</i>		

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Date:

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
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Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

0.00



HandFinish

Memo

0.00

Hand Finishing

= 11 08/01/09 @ 4

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ ☐ Sikaflex-291 ☐ 1112391

Sikaflex expire date: 10/20

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R ☐ ☐ ☐ Sikaflex-291 ☐ 1112391

Sikaflex expire date: 10/20

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: 1112106

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Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

275 08/26/09



Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220

Packaging

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPPD205-634-041

Location:

PPP Rev:

PPD 51497

Responsible

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

09/10/23

Quality Control

MF
09-10-23

W/O:		WORK ORDER CHANGES					
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Picklist Print

August 25, 2009 1:34:23 PM

Page 1

Work Order ID: 51511

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/24/09

Required Date: 8/24/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2580-1RevD		Manufactured	No			110	Each	14.0000	1.0000			

205 Skidtube bent detail

DP 9-9-2
B51743
①

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	13	
50757	3	
50761	6	
50976	2	
50977	2	
Main Warehouse		
ST	1	
50758	1	

D2576-3RevG

Manufactured No

140 Each 141.0000 1.0000



Step (maching detail)

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	141	
43504	40	
46661	101	

1 8D 09.09.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 8/24/09

Required Date: 8/24/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2579RevE		Manufactured	No			140	Each	464.0000	20.0000			



Crossbolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	464	
43988	4	
46434	4	
46956	2	
47797	9	
48272	22	
51314	100	
51315	323	

B-51525
AWM 9-9-09
[Signature]

D2855RevA

Manufactured No

200

Each

29.0000

1.0000



Cap

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	-1	
50513	-1	
Main Warehouse		
FP6	31	
50513	31	
Main Warehouse		
ST	-1	
50513	-1	

B50770

XI [Signature] 09/10/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 8/24/09

Required Date: 8/24/09


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-5A  Bolt		Purchased	No			200	Each	2,515.000	2.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2515	
100188	212	
105057	2245	
15205	58	

XZ 41 09/10/09

AN960JD10L  Washer		Purchased	No			200	Each	6,679.000	2.0000			
---	--	-----------	----	--	--	-----	------	-----------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	-2	
109632	-2	
Main Warehouse		
ST	6681	
101291	16	
104885	153	
105793	236	
109632	1276	
110985	5000	

XZ 41 09/10/09

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ALS7-1032-130		Purchased	No			200	Each	3,628.000	50.0000			



Insert

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

M110511

3628

x50

09/10/09

105855

16

108606

52

111529

1560

111779

2000

AN3C4A

Purchased

No

200

Each

632.0000

50.0000



BOLT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

-50

112314

-50

Main Warehouse

ST

682

112082

30

112314

652

M112720

x50

09/10/08

W/O:		WORK ORDER CHANGES					
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AN960C10L		Purchased	No			200	Each	2,946.000	50.0000			



washer



Warehouse
Location

Loc Qty

Loc Code

OFFSHORE

FG

100

103585

100

Main Warehouse

FP

-50

112116

-50

Main Warehouse

ST

2896

112116

2896

1112612 x50 09/10/08

D3566-13RevC

Manufactured

No

200

Each

20.0000

1.0000



Gasket



Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

FP

-1

48166

-1

Main Warehouse

ST

21

45717

1

46889

1

48166

3

50265

16

1351606 x1 09/10/08

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D3566-5RevC		Manufactured	No			200	Each	17.0000	1.0000			



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP19

-1

51260

-1

Main Warehouse

ST

18

36113

1

46186

1

47318

1

48167

1

51260

14

D3566-1RevC

Manufactured No

200

Each

27.0000

2.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

-2

51259

-2

Main Warehouse

ST

29

46349

1

47434

2

51218

1

51259

25

August 25, 2009 1:34:23 PM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
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D3564-11RevD		Manufactured	No			200	Each	29.0000	1.0000			
 												
Wearshoe												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

22

51256

22

Main Warehouse

FP19

-1

50112

-1

Main Warehouse

ST

8

45823

1

50112

7

B52125

x1 41 09/10/08

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Shop Packet Print

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 25, 2009 1:34:23 PM

Work Order ID: 51511

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/24/09

Required Date: 8/24/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-13RevD		Manufactured	No			200	Each	30.0000	1.0000			



Wearshoe



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP17

17

50270

17

Main Warehouse

FP19

-1

50270

-1

Main Warehouse

ST

14

45409

3

46495

10

47867

1

1352059 X1 9/04/10/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 25, 2009 1:34:24 PM

Page 9

Work Order ID: 51511

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube


Comments:

Start Date: 8/24/09

Required Date: 8/24/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-9RevD		Manufactured	No			200	Each	20.0000	1.0000			
												
Wearshoe												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP19

-2

51258

-2

Main Warehouse

ST

22

44659

1

45825

1

51258

20

D3564-5RevD

Manufactured

No

200

Each

17.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

2

34806

2

Main Warehouse

FP19

15

48555

1

51257

14

B51675

X1 24 09/10/09

August 25, 2009 1:34:24 PM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 25, 2009 1:34:24 PM

Work Order ID: 51511

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/24/09

Required Date: 8/24/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2594-3RevC

Manufactured

No

200

Each

542.0000

16.0000



O-Ring, 205 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

542

27168

44

29908

498

B51613 x16 H/ 09/10/08

D2594-1RevC

Manufactured

No

200

Each

348.0000

16.0000



Plug, 205 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

348

42221

16

42807

92

43884

3

46435

2

47251

235

B51757 x16 H/ 09/10/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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51511

RELEASED
07-06-28

Diagram illustrating the grinding locations and features for the D2576-3 step. The diagram shows a cross-section of the step with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576
- 1/4

Technical drawing of a circular plate with a central hole. The drawing includes the following dimensions and assembly instructions:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Points to two small circles on the plate.
- #0.208**: Dimension for the diameter of the two small circles.
- SEAL WITH SIKAFLEX-241/-291**: Points to the gap between the plate and the central hole.
- AN3-5A BOLT (1)**: Points to the central hole.
- AN960JD10L WASHER (1)**: Points to the central hole.
- (2 PLACES)**: Points to the two small circles.
- D2855 CAP**: Points to the central hole.
- 0.40**: Dimension for the thickness of the plate.

Diagram of a circular component with labels:

- D2579 SPACER
- D2596 WEB (REF)
- ALS7-1032-130 (REF) (TYP 50 PLACES)

5

AFTER BRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

37.50
DISTANCE TO AFT END
OF D2596 WEB

3
7

1.750 1.750

#0.508 (TYP.)
(40 PLACES)

REFER TO DETAIL A

8.750

17.375

26.000


34.188

57.313 (REF)
7 EQUAL SPACES
8.188 PITCH

38.0

91.500

190.0
(D2500-1)

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	CHECKED	APPROVED		DRAWING NO.	REV. D
				D2580	SHEET 2 OF 3
	DATE	TITLE			SCALE
	07.02.27		205 SKIDTUBE ASSEMBLY	1:24	

5/5/5

RELEASED
07 Dec 28

Diagram illustrating the grinding locations for the propeller cross-section:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576

Technical drawing of a circular component with the following specifications:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)
- SEAL WITH SIKAFLEX-241/-291
- AN3-SA BOLT (1)
- AN960J10L WASHER (1) (2 PLACES)
- SEE NOTE ii)
- D2855 CAP
- 0.40

Diagram of a circular component with labels: D2579 SPACER, D2596 WEB (REF), and ALS7-1032-130 (REF) (TYP. 50 PLACES). A note indicates drilling and bending assembly steps.

AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

37.50
DISTANCE TO AFT END
OF D2596 WEB

3
7

1.750 1.750

#0.508 (TYP.)
(40 PLACES)

REFER TO DETAIL E

REFER TO DETAIL A

8.750

17.375

26.000

34.188


57.313 (REF)
7 EQUAL SPACES
B.188 PITCH

38.0

91.500

190.0
(D2500-1)

[illegible][illegible]

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	CHECKED	APPROVED		DRAWING NO.	REV. D
	DATE	TITLE			SHEET 3 OF 3
	07.02.27	205 SKIDTUBE ASSEMBLY			SCALE 1:24

51511

NO. 210

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Pet. Duml
Job number: 51511
Part number: A205-634-041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pet. Duml Date of Test Coupon 09/10/02
Welder Pet. Duml Date of Test Coupon 09.10.02

The above named individual is qualified in accordance with AWS D17.1.2001 to weld